POXYLUBE® #845

(FORMERLY EXPERIMENTAL PRODUCT: X127)

ACRYLIC PTFE BAKING ENAMEL: HEAT CURE

SERIES A845

SATIN FINISH

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DESCRIPTION

Poxylube® #845 Acrylic PTFE Baking Enamel provides a durable satin finish with excellent UV light resistance. This versatile solventborne single component coating is optimized for spray application.

OUTSTANDING FEATURES/BENEFITS

- Excellent UV weatherability and gloss retention
- Fast cure response
- Lubricity through PTFE reduces friction in applications with surface contact.

TYPICAL USES

- On coating fasteners
- As UV protective finish
- As light reflective finish

NOTICE

Before using this product, read all warnings, limitations and safety information printed on the product label, Safety Data Sheet (MSDS) and Technical Data Sheet.

LIMITATIONS

- Do not use where temperatures regularly exceed 400°F.
- Product not suitable for food contact or food processing equipment.

COMPOSITION AND PHYSICAL PROPERTIES			
Net Weight per gallon	8.0 - 12.0 lbs./gallon (Theoretical)	**Vehicle**	Acrylic
Weight Solids	55 - 70% (Theoretical) *Varies by color*	**Lubricating Pigment**	PTFE
Volume Solids	45 - 50% (Theoretical)	**Color**	Black (Custom Colors Available)
VOC	2.5 - 3.5 lbs./gallon	**Finish**	Smooth and Satin
Odor	Strong solvent	**Gloss**	25 - 35 gloss units at 60°
Viscosity	60 - 70 KU @ 77°F	**Pot Life**	N/A
Shelf Life	12 months from date of manufacture	**Coverage Rate***	1400-1600 sq. ft./gallon @ .5 mil DFT
Storage Conditions	32°F to100°F	**Recommended Coats**	1
Freeze/Thaw Stability	Stable	**Dry Film Thickness**	.5 – .75 mils

*Actual figures do not include spray loss. Also allow for surface irregularities and porosity, as well as material loss when mixing.

PERFORMANCE AND FUNCTIONAL PROPERTIES				
Chemical Resistance *24 hours @ R.T.*	Brake Fluid	No Effect	**CS-17 Taber Abrasion** *ASTM D4060*	126 mg/1,000 cycles
	Penetrating Oil	No Effect	**Adhesion** *ASTM D3359*	5B over cold rolled steel
	WD-40	No Effect	**Hardness**	F pencil
	Anti-Seize Compound	No Effect	**Operating Temperature Range**	-300°F to 400°F

GENERAL
This product is a heat curing acrylic baking enamel, optimized for spraying and dip spin application. For maximum service, the APPLICATION INSTRUCTIONS MUST BE FOLLOWED CLOSELY.

FILM THICKNESS & ENGINEERING TOLERANCE
As supplied, this product will yield a film thickness of about .0005 to .0075 inches per spray application.

COVERAGE
One gallon of this material will cover 1400 - 1600 sq. ft. with a dry film thickness of 0.005 inches. Coverage depends upon methods of application and other variables such as overspray and type of surface to be coated. Above coverage rates are based on 100% efficiency.

SURFACE PREPARATION
It is recommended that the surface be thoroughly de-greased with a suitable solvent and grit blasted and/or zinc, iron, or manganese phosphate pre-treatment be applied for best results. Minimum preparation requires the surface be dry and free of dust and greases or oils.

IMPORTANT! ***DO NOT TOUCH CLEAN SURFACE WITH FINGERS - OIL FROM THE HANDS WILL INTERFERE WITH PROPER COATING ADHESION.*** Whenever possible, treat both contact surfaces (i.e., the shaft and the bearing).

STIRRING
IMPORTANT! STIR THOROUGHLY BEFORE USE AND INTERMITTENTLY DURING APPLICATION.

THINNING
For spray application it is recommended to thin the coating 2:1 based on volume with D159-C01. Optimal thinning must be determined for each individual dip spin assembly.

APPLICATION
For spraying – Thin as described above and spray as any conventional paint. Note: if air assisted airless spray equipment is used, ensure the spray tip orifice is greater than 0.001 cm.

BAKING / CURING
After application and prior to being placed in an oven, it is recommended that parts flash off for 20 minutes @ 77°F ± 5°F and ≤70% relative humidity. Once the parts are dry, bake at 400°F for 20 minutes or 300°F for 60 minutes to reach full cure and attain full mechanical characteristics.

IMPORTANT! The time starts when **the part** reaches temperature, not when placed in a Class A oven.

CLEANUP
Wet product may be wiped away with a rag. If product is dry but not cured, a solvent such as MEK or acetone may be used.

REMOVAL
It is recommended that the cured film be removed by abrasive blasting or sanding.

WARNINGS: Intermittent stirring is imperative for best results.

DANGER! USE WITH ADEQUATE VENTILATION.